

Work Order ID 151718

Friday, October 07, 2016 2:33:31 PM

151718

Page 1

Item ID: D4435-041 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Bracket Assembly
 Start Date: 10/3/2016 Start Qty: 6.00 ***6*** Cust Item ID:
 Required Date: 10/7/2016 Req'd Qty: 6.00 ***6*** Customer:
 Reference:

Approvals: Process Plan: VS 16/10/11 Date: 16/10/11 Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D4435	B								PR 16/10/17
100		0.00							
100	FLOW WATER JET								
Waterjet	Memo	0.06							
FLOW CNC Waterjet	1-Cut D4435-1 as per Dwg Dwg Rev: <u>B</u> Prog Rev: <u>B</u> 2-Deburr if necessary								
110		0.00							
110	QC2- Inspect parts off machine FAI/FAIB								
QC	Memo	0.01							
Quality Control									
120		0.00							
120	QC8- Inspect parts - second check								
QC	Memo	0.02							
Quality Control									

DAS
38
9-89

OCT 18 2016

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Item ID: D4435-041

Accept

N900040100

Setup Start

NS1

Revision ID:

Item Name: Bracket Assembly

Stop

NS2

Start Date: 10/3/2016 Start Qty: 6.00

6

Cust Item ID:

Required Date: 10/7/2016 Req'd Qty: 6.00

6

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run

Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	Chemical Conversion Coat per QSI005 4.1	0.00							
130									
HandFinish	Memo	0.05				(x6)			2/16/16
Hand Finishing									BEB
135	QC7-Inspect Chemical Conversion Coat	0.00							
135									
QC	Memo	0.01							
Quality Control									6 6 16-10-20 DAS 34
140	Black Sandtex(Ref:4.3,5,7) per QSI005 4.3	0.00							
140									
Powdercoat	Memo	0.03							
Powder Coating	START TIME: 8:30								
	OVEN TEMPERATURE: 320°								
	FINISH TIME: 7:00								

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[illegible]

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Item ID: D4435-041 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Bracket Assembly
Start Date: 10/3/2016 Start Qty: 6.00 ***6*** Cust Item ID:
Required Date: 10/7/2016 Req'd Qty: 6.00 ***6*** Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
190 *190* Packaging Packaging	Identify as per dwg & Stock Location *098 Memo	0.00 0.01				6	DEC 13 2016		DAS 6 9-89
200 *200* QC Quality Control	QC21- Final Inspection - Work Order Release Memo	0.00 0.10						DEC 14 2016	DAS 21 9-89 mf 16-12-13

Picklist Print

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Work Order ID: 151718

151718

Parent Item: D4435-041

D4435-041

Parent Item Name: Bracket Assembly

Start Date: 10/3/2016

Required Date: 10/7/2016

Start Qty: 6.00

Required Qty: 6.00

Comments: IPP REV:A 11.10.05 NEW ISSUE DD VERF:EC IPP
REV:B 12.03.06 AS PER DWG REV.B DD VERF:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D4441-1		Manufactured	No			160	f	0.0001	0.2916	1.7496			
D4441-1									**			FF	DEC 08 2016
Rubber Seal													

Location	Loc Qty	Loc Code
ST422	0.0001	
120932	0.0001	

1.7496

M6061T6S.040 Purchased No

100 sf 364.3000 0.043 0.258

M6061T6S 040

6061-T6 .040 Sheet

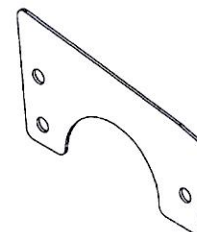
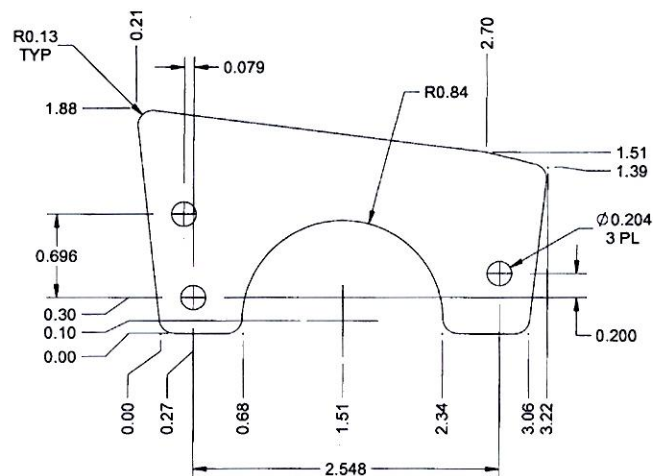
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PR 16/10/17

Location	Loc Qty	Loc Code
MAT021	364.3	
m135147	7.4	
m135612	43	
m135632	124.1	
m135724	189.8	

0.3

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RETURN TO
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UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 151918



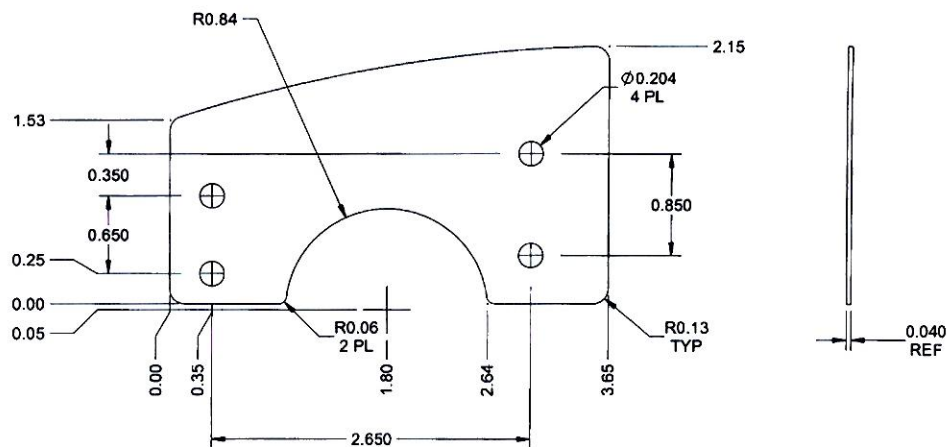
D4435-1 BRACKET

NOTES:

- 1) MATERIAL: 6061-T6/T62 ALUMINUM SHEET 0.040 THICK
PER QQ-A-250/11 OR AMS-QQ-A-250/11
OR AMS 4025 OR AMS 4027
OR ASTM B209
REF DART SPEC. M6061T6S.040
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT "BLACK SANDTEX" (4.3.5.7) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.02 lbs

RELEASED
2012-03-02

DESIGN	RF	DART AEROSPACE LTD	
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED	140	DRAWING NO.	REV. B
MFG. APPR.	140	D4435	SHEET 4 OF 11
APPROVED	140	TITLE	SCALE
DE APPR.	140	BRACKET	
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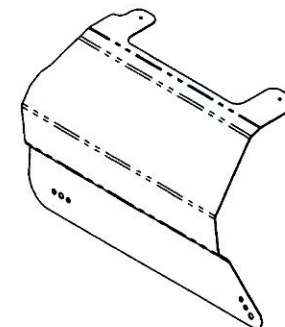
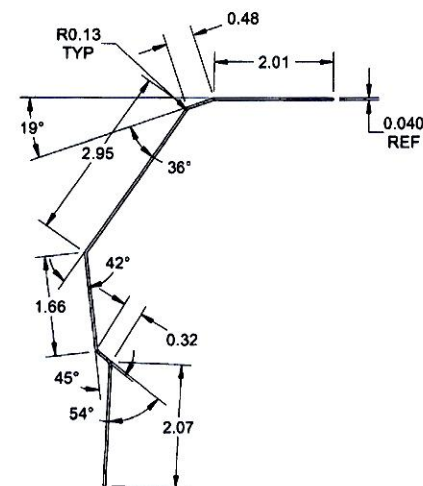
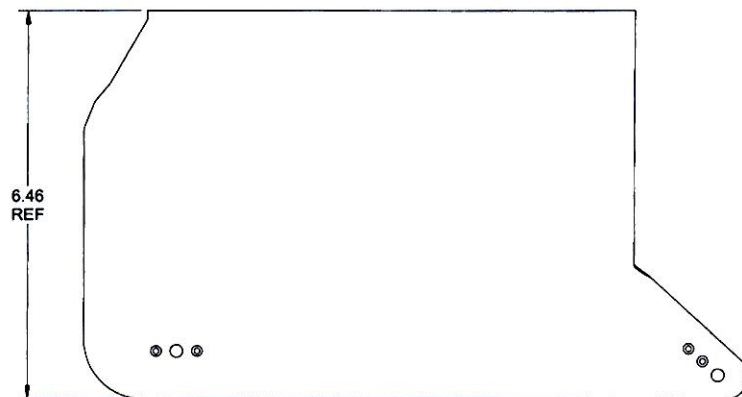
D4435-3 BRACKET

NOTES:

- 1) MATERIAL: 6061-T6/T62 ALUMINUM SHEET 0.040 THICK
PER QQ-A-250/11 OR AMS-QQ-A-250/11
OR AMS 4025 OR AMS 4027
OR ASTM B209
REF DART SPEC. M6061T6S.040
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT "BLACK SANTEX" (4.3.5.7) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.023 lbs

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DRAWN	RF		
CHECKED	140	DRAWING NO.	REV. B
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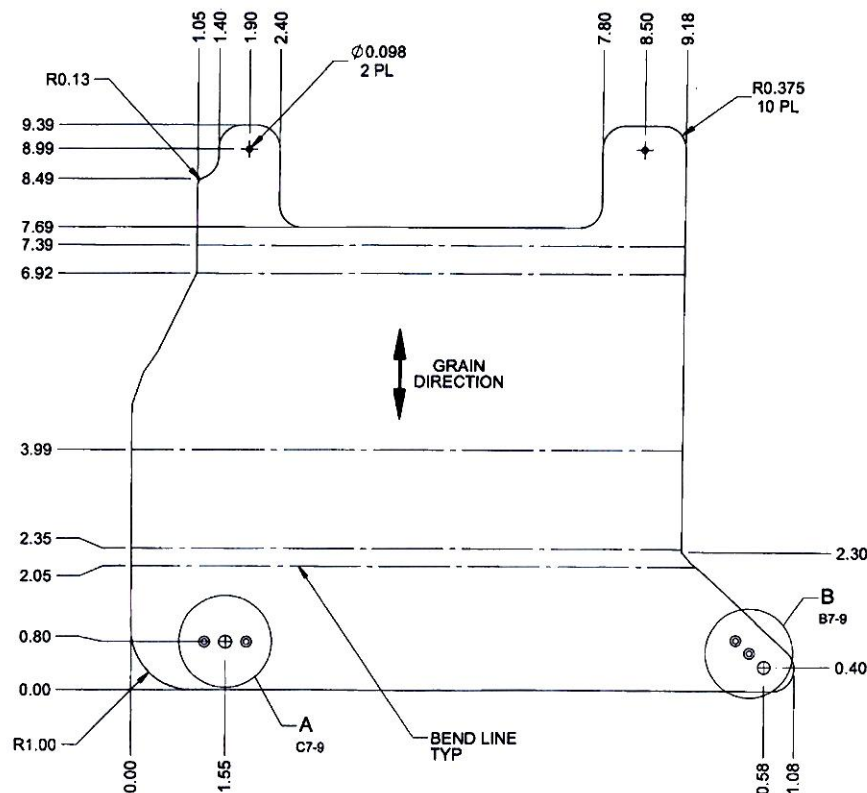
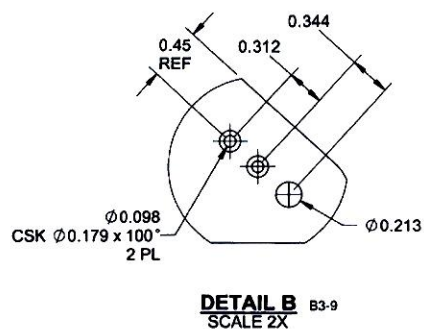
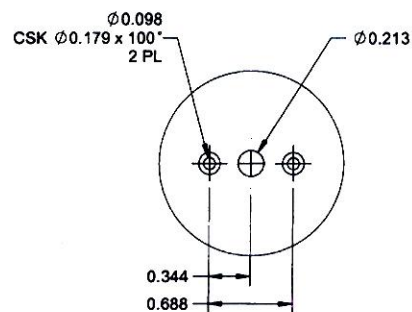
D4435-7 BRACKET

RELEASING
2012-03-02
JMD

NOTES:

- 1) MATERIAL: MAKE FROM D4435-7F FLAT PATTERN
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.29 lbs

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D4435-7F FLAT PATTERN

NOTES:

- 1) MATERIAL: 6061-T6/T62 ALUMINUM SHEET 0.040 THICK
PER QQ-A-250/11 OR AMS-QQ-A-250/11
OR AMS 4025 OR AMS 4027
OR ASTM B209
REF DART SPEC. M6061T6S.040
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.29 lbs

DESIGN	RF	DART AEROSPACE LTD	
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